

Claims

1. (Previously presented) A disposable shaped paperboard food container with a bilayer finish press-formed in a heated die set from a paperboard blank,

said paperboard blank being prepared from a paperboard substrate provided with a first finish coating layer consisting essentially of a styrene-butadiene resin composition and a second, top coating finish layer consisting essentially of an acrylic resin composition applied to said first finish coating layer wherein said first and second coatings contain up to about 2 lbs of mineral filler per 3,000 square foot ream and, wherein said food container exhibits a surface gloss of at least about 40 gloss units as measured by test method ASTM D523-89, 60 degree method.

2. (Previously presented) The paperboard food container according to Claim 1, wherein said food container exhibits a surface gloss of at least about 50 gloss units as measured by test method ASTM D523-89, 60 degree method.
3. (Previously presented) The paperboard food container according to Claim 1, wherein said food container exhibits a surface gloss of between about 45 gloss units and about 65 gloss units as measured by test method ASTM D523-89, 60 degree method.
4. (Previously presented) The paperboard food container according to Claim 1, wherein said styrene-butadiene resin composition and said acrylic resin composition are aqueous emulsions.
5. (Previously presented) The paperboard food container according to Claim 1, wherein said first finish coating layer is applied to said paperboard substrate in an amount of from about 0.25 pounds to about 1.5 pounds per 3,000 square foot ream.
6. (Previously presented) The paperboard food container according to Claim 5, wherein said first finish coating layer is applied to said paperboard substrate in an amount of at least about 0.5 pounds per 3,000 square foot ream.

7. (Previously presented) The paperboard food container according to Claim 6, wherein said first finish coating layer is applied to said paperboard substrate in an amount of from about 0.6 pounds to about 1 pound per 3,000 square foot ream.
8. (Previously presented) The paperboard food container according to Claim 1, wherein said second top finish coating layer is applied to said paperboard substrate in an amount of at least about 0.5 pounds per 3,000 square foot ream.
9. (Previously presented) The paperboard food container according to Claim 1, wherein said second top finish coating layer is applied to said paperboard substrate in an amount of from about 0.25 pounds to about 1 pound per 3,000 square foot ream.
10. (Previously presented) The paperboard food container according to Claim 1, wherein said styrene-butadiene resin composition comprises a carboxylated styrene-butadiene resin.
11. (Previously presented) The paperboard food container according to Claim 1, wherein said paperboard substrate has a basis weight of from about 100 to about 300 pounds per 3,000 square foot ream.
12. (Previously presented) The paperboard food container according to Claim 11, wherein said paperboard substrate has a basis weight of from about 125 pounds to about 150 pounds per 3,000 square foot ream.
13. (Previously presented) The paperboard food container according to Claim 11, wherein said paperboard substrate has a basis weight of from about 150 to about 200 pounds per square foot ream.
14. (Previously presented) The paperboard food container according to Claim 1, wherein said paperboard substrate is sized with a starch composition in an amount of from about 4 to about 15 pounds per 3,000 square foot ream and provided with a clay coating prior to being coated with said first finish coating layer.

15. (Previously presented) The paperboard food container according to Claim 14, wherein said paperboard substrate is coated with one or more clay coatings in a coatweight amount of from about 8 lbs of clay coating per 3,000 square foot ream to about 24 lbs of clay coating per 3,000 square foot ream underneath with said first and second finish coating layers.
16. (Previously presented) The paperboard food container according to Claim 1, wherein the forming surfaces of said heated die set are maintained at a temperature of from about 250° F to about 400° F during pressing of said container.
21. (Previously presented) A coated paperboard for making a paperboard food container with a bilayer finish wherein said container exhibits a surface gloss of at least about 40 gloss units as measured by test method ASTM D523-89, 60 degree method, said coated paperboard comprising:
- a) a paperboard substrate sized with from about 4 pounds of starch per 3,000 square foot ream to about 15 pounds of starch per 3,000 square foot ream and provided with a clay coating;
 - b) a first finish coating layer consisting essentially of a styrene – butadiene resin composition applied to said clay coating; and
 - c) a second finish top coat layer consisting essentially of an acrylic resin composition applied to said first layer wherein said first and second finish coatings contain up to about 2 lbs of mineral filler per 3,000 square foot ream.
22. (Previously presented) The coated paperboard according to Claim 21, wherein said paperboard substrate is coated with one or more clay coatings in a coatweight amount of from 8 lbs of clay coating to about 24 lbs of clay coating per 3,000 square foot ream underneath said first finish coating layer and said second finish top coat layer.

23. (Previously presented) The coated paperboard food container according to Claim 21, wherein said styrene-butadiene resin composition and said acrylic resin composition are aqueous emulsions.
24. (Original) The coated paperboard according to Claim 21, wherein said first finish coating layer is applied to said paperboard substrate in an amount of from about 0.25 pounds to about 1.5 pounds per 3,000 square foot ream.
25. (Original) The coated paperboard according to Claim 24, wherein said first finish coating layer is applied to said paperboard substrate in an amount of at least about 0.5 pounds per 3,000 square foot ream.
26. (Original) The coated paperboard according to Claim 25 wherein said first finish coating layer is applied to said paperboard substrate in an amount of from about 0.6 pounds to about 1 pound per 3,000 square foot ream.
27. (Original) The coated paperboard according to Claim 21, wherein said second top finish coating layer is applied to said paperboard substrate in an amount of at least about 0.5 pounds per 3,000 square foot ream.
28. (Original) The coated paperboard according to Claim 27, wherein said second top finish coating layer is applied to said paperboard substrate in an amount of from about 0.25 pounds to about 1 pound per 3,000 square foot ream.
29. (Original) The coated paperboard according to Claim 29, wherein said styrene-butadiene resin composition comprises a carboxylated styrene-butadiene resin.
36. (Previously presented) The paperboard food container according to Claim 1, wherein said food container exhibits a surface gloss of 45 or more gloss units as measured by test method ASTM D523-89, 60 degree method.

37. (Previously presented) The coated paperboard according to Claim 21, formed into a container exhibiting a surface gloss of 45 or more gloss units as measured by test method ASTM D523-89, 60 degree method.

38. (Previously presented) A disposable shaped paperboard food container with a bilayer finish press-formed in a heated die set from a paperboard blank,

said paperboard blank being prepared from a paperboard substrate provided with a first finish coating layer consisting essentially of a styrene-butadiene resin composition without mineral filler and a second, top coating finish layer consisting of an acrylic resin composition without mineral filler applied to said first finish coating layer, wherein said food container exhibits a surface gloss of at least about 40 gloss units as measured by test method ASTM D523-89, 60 degree method.

39. (Previously presented) The paperboard container according to Claim 36, wherein said food container exhibits a surface gloss of 45 or more gloss units as measured by test method ASTM D523-89, 60 degree method.

40. (Previously presented) The paperboard food container according to Claim 36, wherein said food container exhibits a surface gloss of at least about 50 gloss units as measured by test method ASTM D523-89, 60 degree method.

41. (Previously presented) The paperboard food container according to Claim 36, wherein said food container exhibits a surface gloss of between about 45 gloss units and about 65 gloss units as measured by test method ASTM D523-89, 60 degree method.

42. (Previously presented) The paperboard food container according to Claim 36, wherein said styrene-butadiene resin composition and said acrylic resin composition are aqueous emulsions.

43. (Previously presented) The paperboard food container according to Claim 36, wherein said first finish coating layer is applied to said paperboard substrate in an amount of from about 0.25 pounds to about 1.5 pounds per 3,000 square foot ream.

44. (Previously presented) A disposable shaped food container press-formed in a heated die set from paperboard, wherein the container has a finish coating comprising one or more resin layers without mineral filler which finish layer or layers are press-applied to the paperboard and wherein the container exhibits a surface gloss of 45 or more gloss units as measured by ASTM D523-89, 60 degree method.